



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2274
Job Sheet 167308



Part No: D2274

Job Qty: 300 ea **304 pcs TOTAL**

Part Name: Radius Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/27/17

Job Tracking No:

Due Date: 11/10/17

Created By: Linda Lacelle

Type: Stock

Description:

Customer: Rilpa Enterprises Ltd (CRILP01)

480 Aviation Way NE Calgary, AB, T2E 7G3 Canada ph:(403) 275-3035 fx:(403) 730-0170.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	300 Ea		11/9/17	0.00	0.00	Start up container		FM
100	Shear	300 pcs		11/9/17	0.00	0.15	Shear		FM
110	CNC Vertical Machining	300 pcs		11/9/17	0.01	7.18	HAAS 1		FM
130	QC	300 pcs		11/9/17	0.00	0.00	QC8		8-P
140	Small Fab	300 pcs		11/9/17	0.00	1.63	Small Fab		ML
150	HandFinish	300 pcs		11/10/17	0.00	0.77	HandFinish1		2017-11-22 25
160	QC	300 pcs		11/10/17	0.00	0.00	QC7		DAS
170	Packaging	300 pcs		11/10/17	0.00	0.00	Packaging3	Stock	6
180	QC21-SA	300 Ea		11/10/17	0.00	0.00	QC21		9-80

Part Op 100 - blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

Descriptions: 110 - Machine as per folio D2274

140 - Tumble Deburr any rough edges after tumbling

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B00750X00.125	27	55	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Radius Block	0.257inches + 0.005 - 0.000	0.262 0.257		
2	Radius Block	0.750inches ± 0.010	0.760 0.740		
3	Radius Block	0.375inches ± 0.010	0.385 0.365		
4	Radius Block	0.125inches ± 0.010	0.135 0.115		
5	Radius Block	0.750inches ± 0.010	0.760 0.740		
6	Radius Block	0.063inches ± 0.010	0.073 0.053		

Dart Aerospace Ltd.

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

DART
AEROSPACE

S010933



Radius Block

D2274

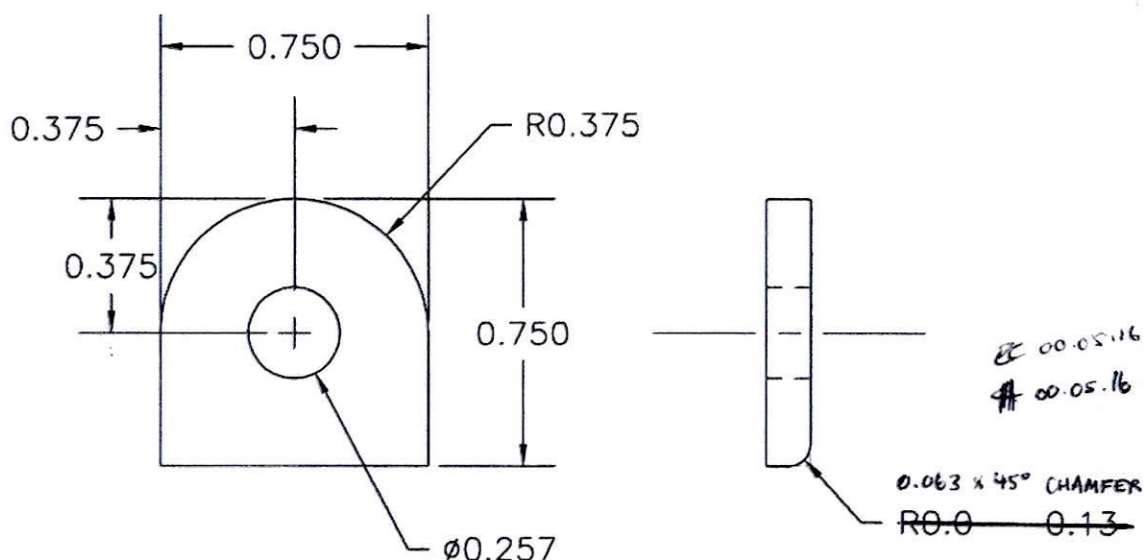
Start up Operation

PART NO:
Revision:
Operation No:
Change No:

Mfg Date: 11/17/17
Job No: 167308

DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/19 KE

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED